

Date: Monday, 02/02/2009 11:50:30 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSEMBLY
Job Number : 45401	
Estimate Number : 10464	
P.O. Number :	Part Number : D3278041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3278 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 44573	Material :
Written By :	Due Date : 15/02/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JLD 09.02.08</u>	
Comment : Est:A 04.04.19 New issue KJ/JLM	
EST B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	45401A	SUPPORT
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**Comment:** Sub-Component SUPPORT

1 x D3278-1 Batch

B44032 (25x)B44573 (15x)

2.0	45401B	SUPPORT
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**Comment:** Sub-Component SUPPORT

1 x D3278-2 Batch

B44033 (20x)B44573 (19x)

3.0	D32783	Spacer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D3278-3 Spacer

B44780

4.0	MS20426AD36	Rivet
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty Part Number Description Batch

4 MS20426AD3-6 Rivet

M105055

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:30 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 45401

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet spacers with support as per Dwg D3278.

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	D22301	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2230-1	Mounting Lug	B43444 (420)

B44700 (382)

8.0	AN413A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	M110322

Ep09/02/06

9.0	AN960JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN960JD416	Washer	M110523

Ep09/02/06

10.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	MS21042L4	Nut	M109282

Ep09/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 45401

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME 09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

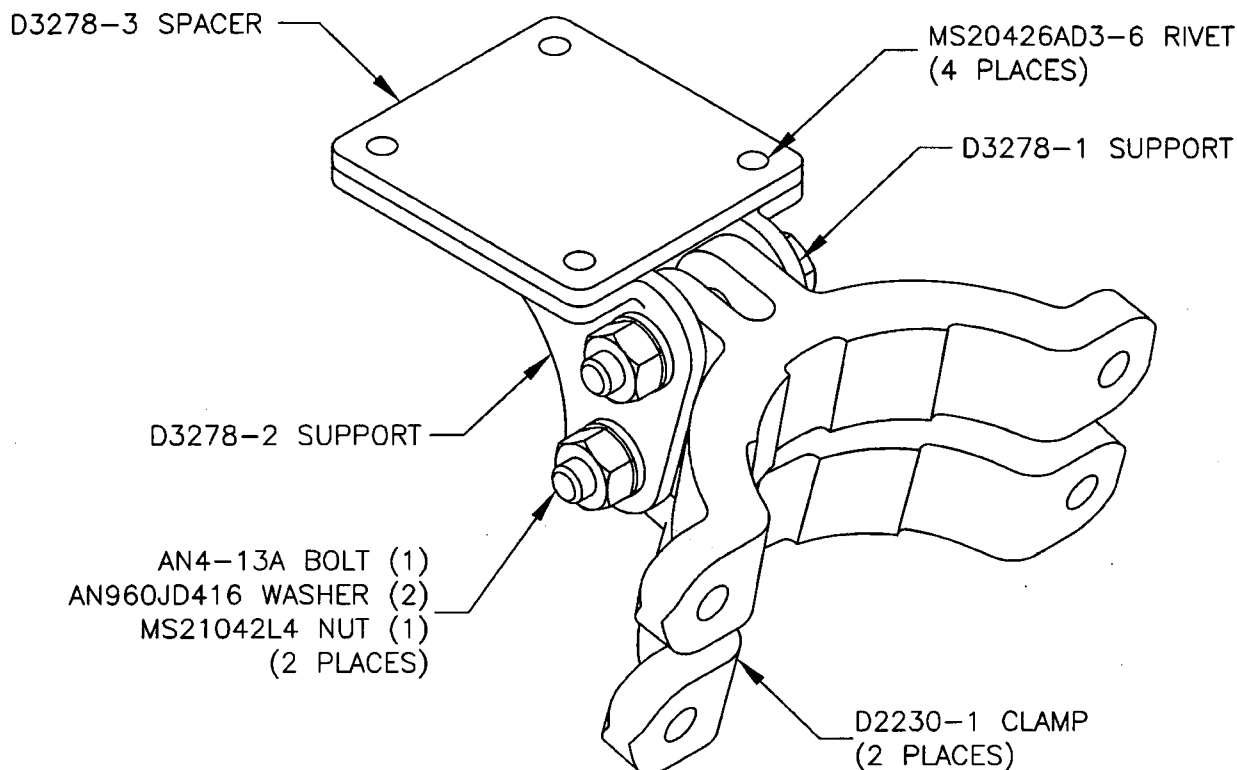
NOTE: Date & initial all entries



DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

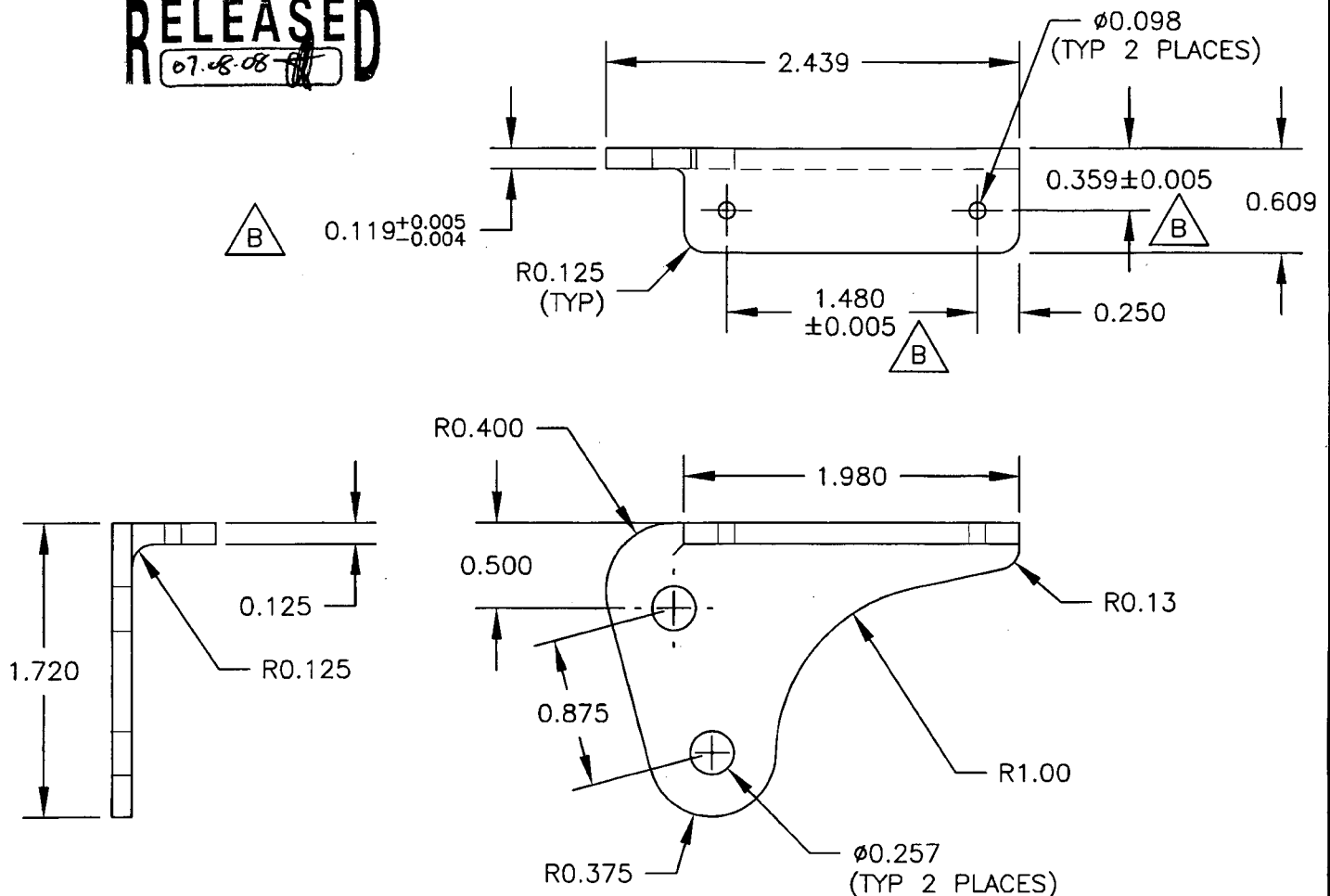
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) SHOP COPY
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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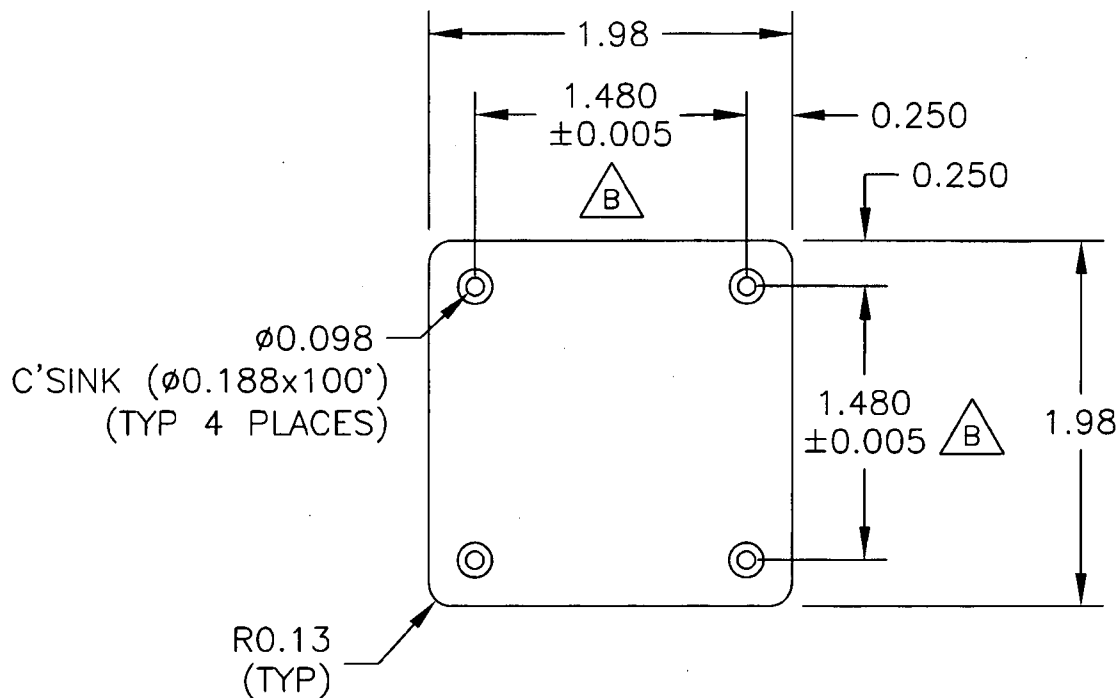
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CHECKED <i>js</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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